

Work Order ID 66575

Tuesday, February 22, 2011 11:06:10 AM

Page 1

Item ID: D3255-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Panel

Start Date: 2/23/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *11-02-22*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3255 ☐ Dwg Rev: *B* ☐ Prog Rev: *B* ☐ 2-
Debur if necessary*304 . 032**B11-2-23**(4)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-2-23

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*Sulor/uff**(4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Form as per Dwg D3255

Sp 11/03/02

(4)

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

Sp 11/03/02

(X9)
2

150

0.00



Packaging

Identify as per dwg & Stock Location: W/A

Memo

0.00

Packaging

a 11-3-2 (X9)

OO

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Page 3

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Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/04 *[Signature]*
MF
11-03-03

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Picklist Print

Tuesday, February 22, 2011 11:06:05 AM

Page 1

Work Order ID: 66575



Parent Item: D3255-2



Parent Item Name: Panel

Start Date: 2/23/2011

Required Date: 3/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	61.2896	1.484	3.124211			



Bill-2-23

304/316 .032 Sheet

Location

Loc Qty

Loc Code

MAT20

61.2896

109023

30.2896

109057

31

109023

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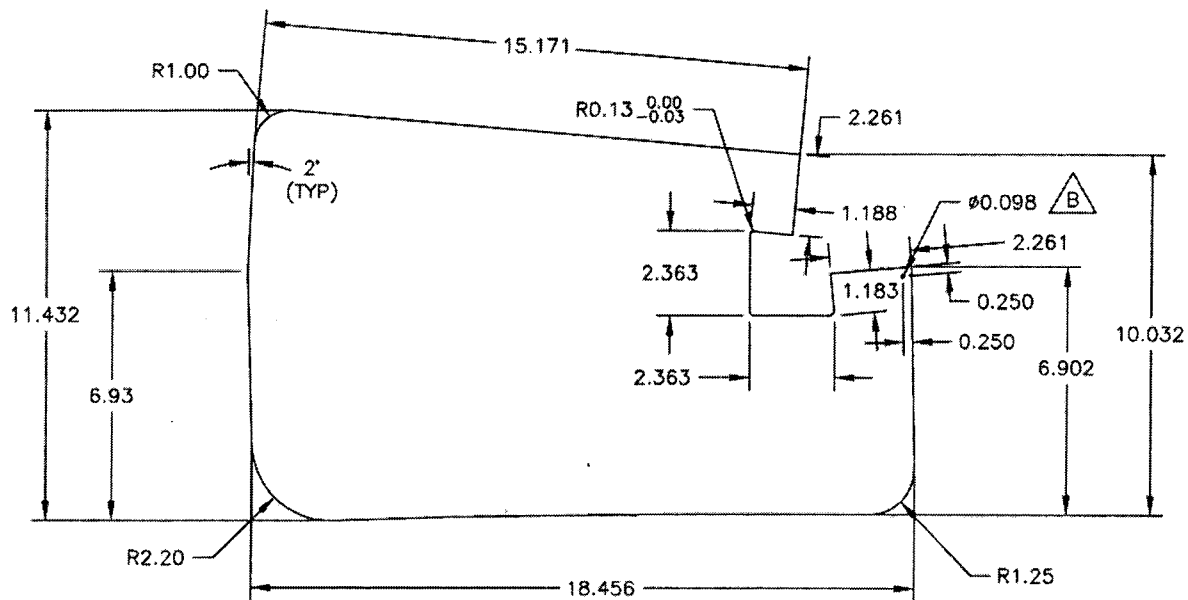
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DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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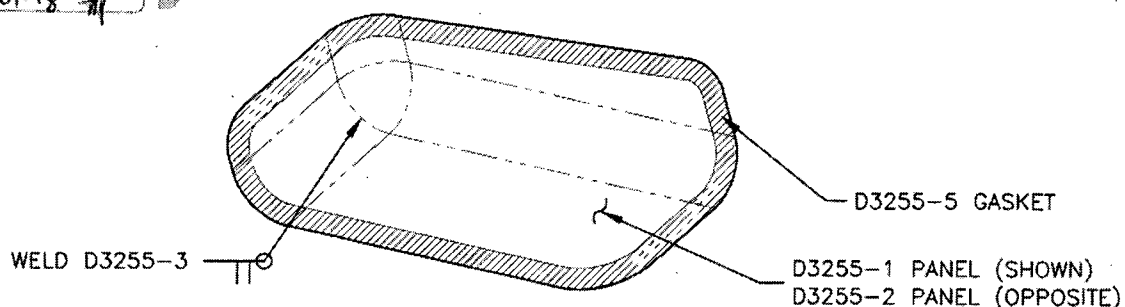
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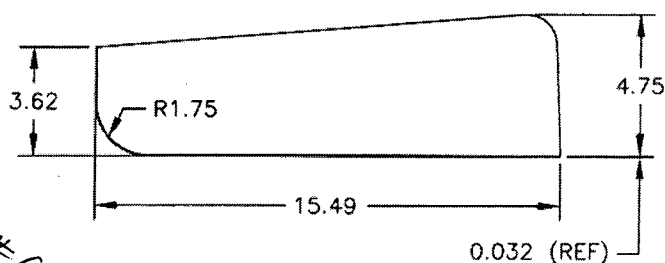
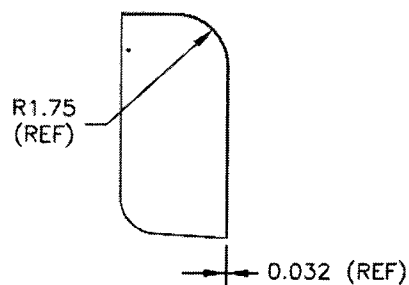
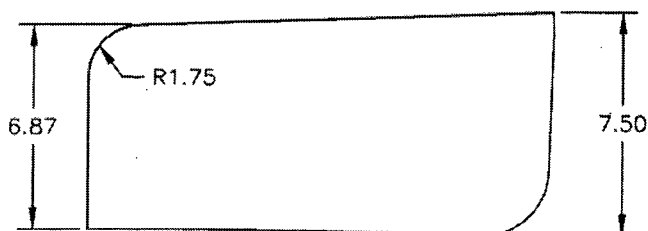


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



#66575

D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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